

Date: Thursday, 6/1/2006 8:36:19 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER KIT
Job Number : 27323E	
Estimate Number : 11452	
P.O. Number : N/A	Part Number : D314057
This Issue : 6/1/2006 S.O. No. : N/A	Drawing Number : D3140 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : D1
Previous Run : 26315	Material : N/A
Written By : <i>See Comment Below</i>	Due Date : 6/8/2006
Checked & Approved By : <i>06.06.01</i>	Qty: 1 Um: Each
Comment : Est. B0211.13 Removed D3140-65/-81/-83; Added D3140-301 K J Est. Rev C New dwg rev. ecn781 06.04.18 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D314009	Doubler Assembly
-----	---------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Doubler Assembly

Pick:

Qty	Part Number	Description	Batch
1	D3140-09	Doubler Assy	18467

2.0	D3140101
-----	----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Doubler

Pick:

Qty	Part Number	Description	Batch
2	D3140-101	Doubler	26723

3.0	D3140241	Doubler
-----	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Doubler

Pick:

Qty	Part Number	Description	Batch
1	D3140-241	Doubler	18470

4.0	D3140301	Doubler
-----	----------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Doubler

Pick:

Qty	Part Number	Description	Batch
			26797

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/1/2006 8:36:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER KIT

Job Number: 27323E

Part Number: D314057

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D3140-301 Doubler

5.0

D314087

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty	Part Number	Description	Batch
1	D3140-87	Doubler	25729

6.0

D314091

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty	Part Number	Description	Batch
1	D3140-91	Doubler	25730

7.0

D314095

Doubler



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Doubler

Pick:

Qty	Part Number	Description	Batch
3	D3140-95	Doubler	25731

8.0

D314097

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Pick:

Qty	Part Number	Description	Batch
1	D3140-97	Doubler	26724

9.0

D314099

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)


Doubler

Pick:

Qty	Part Number	Description	Batch
1	D3140-99	Doubler	26722

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/1/2006 8:36:19 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER KIT

Job Number: 27323E

Part Number: D314057

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3140103

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3140-103	Doubler	25736

11.0

D3140105

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3140-105	Doubler	25739

W 06-04-28

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C 206104/28 (1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 206104/28 (1)

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

ST 06/06/01

Job Completion



06-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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DATE 05.11.23		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
DI	06.03.31	1.75 WAS 1.88; 4.75 WAS 4.13	

RELEASED
05.12.01 *[Signature]*

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140	REV. D SHEET 2 OF 7
DATE 05.11.23		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED
05.12.01

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

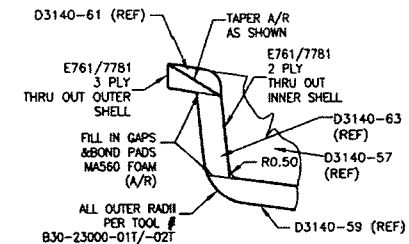
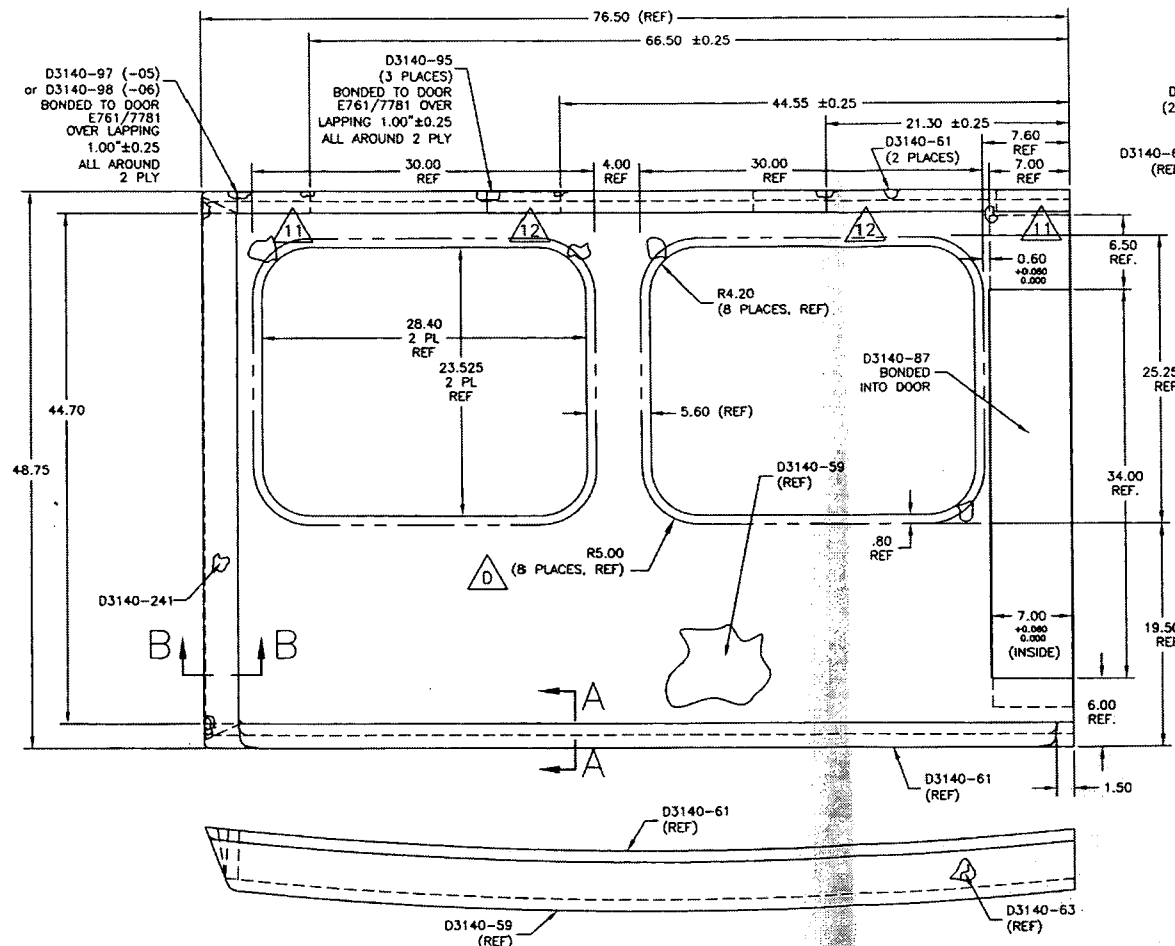
13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

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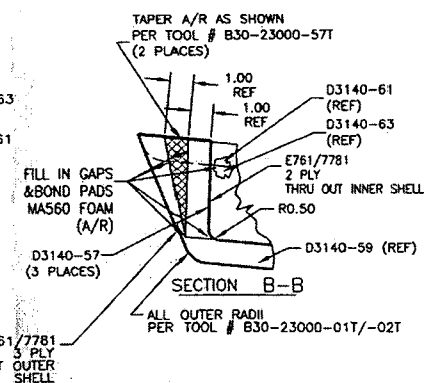
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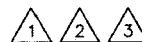
SECTION A-A

RELEASED



SECTION B-B

D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
(WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

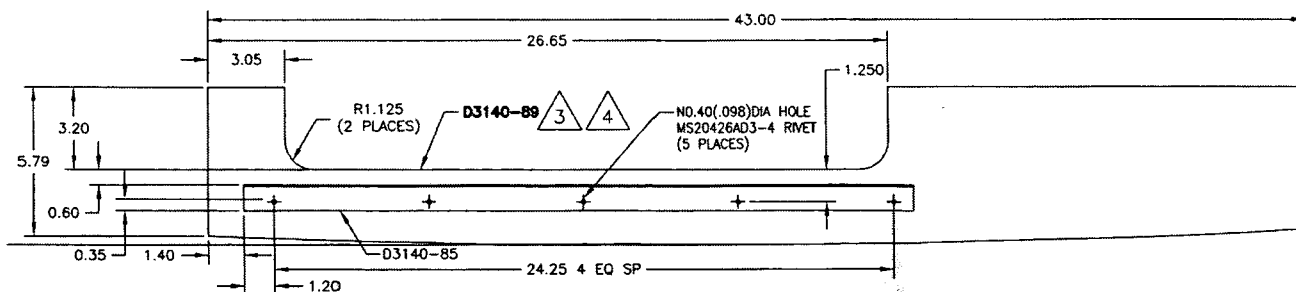


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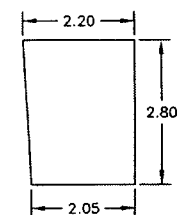
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CHECKED	#	APPROVED	#	DRAWING NO.	D3140
DATE	05.11.23	TITLE	DOOR	REV. 0	SHEET 3 OF 7
				SCALE	NTS

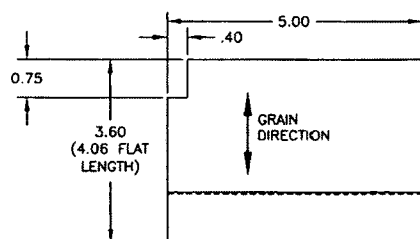
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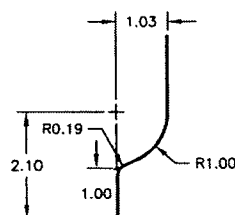
D3140-10 DOUBLER ASSEMBLY (SHOWN, REPLACES PREMIER P/N B30-23000-10)
D3140-09 DOUBLER ASSEMBLY (OPPOSITE, REPLACES PREMIER P/N B30-23000-09)



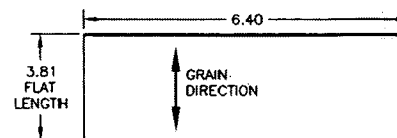
D3140-101 DOUBLER (REPLACES PREMIER P/N B30-23000-101)



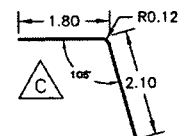
D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)



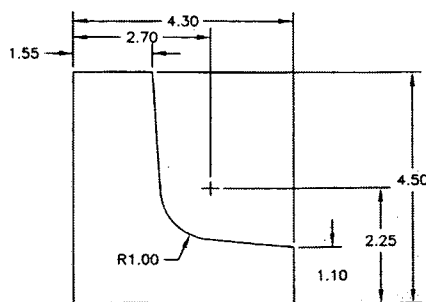
D3140-91 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-91)
D3140-92 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-92)



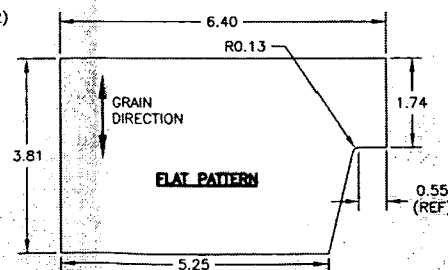
D3140-95 DOUBLER (REPLACES PREMIER P/N B30-23000-95)



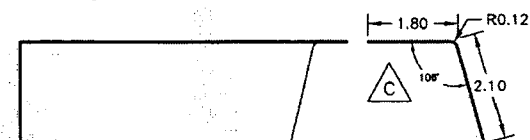
D3140-97 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)



D3140-99 DOUBLER (REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
 (USE TO MAKE D3140-97/-98 DOUBLERS)

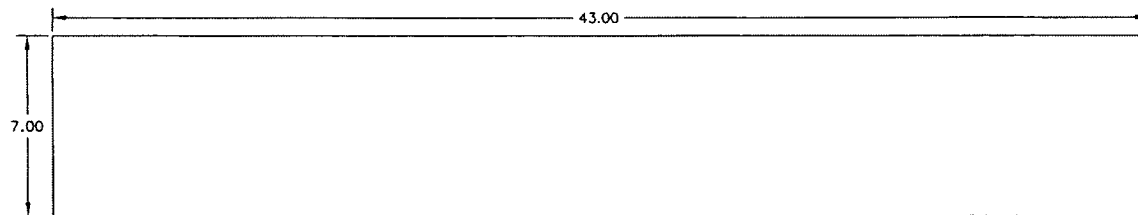


SEND DETAIL

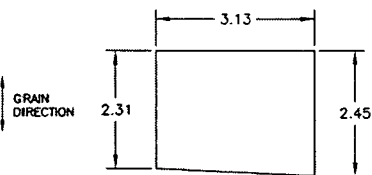
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				DATE 05.11.23				TITLE DOOR	
								REV. D SHEET 5 OF 7	
								SCALE NTS	

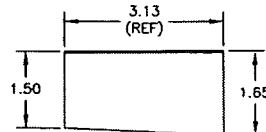
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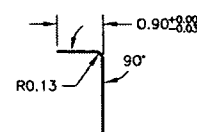
D3140-87 DOUBLER $\triangle 4$
(REPLACES PREMIER P/N B30-23000-87)



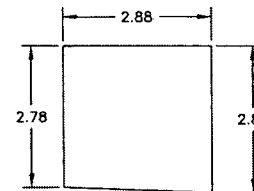
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



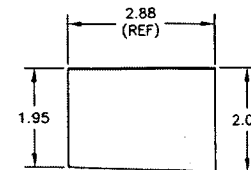
D3140-105 DOUBLER
D3140-106 OPPOSITE



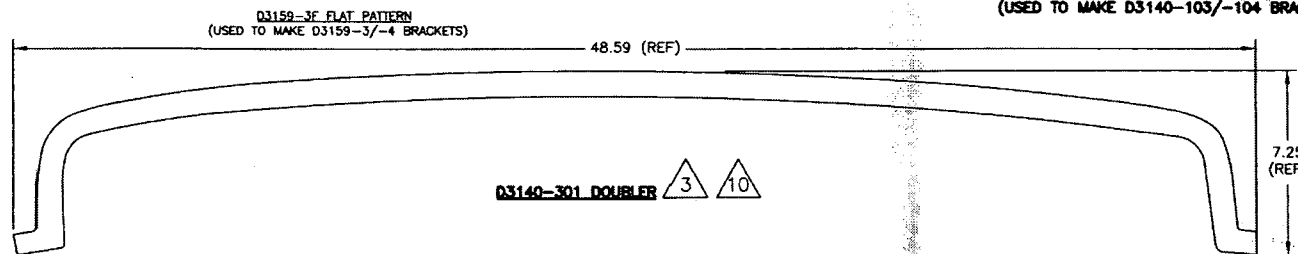
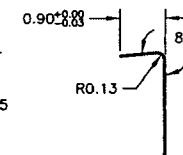
GRAIN DIRECTION



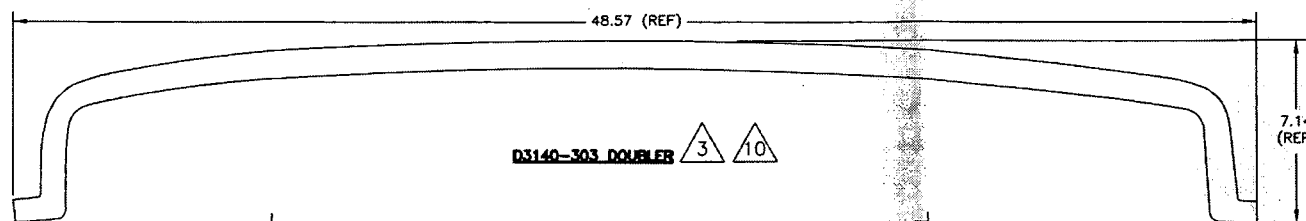
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



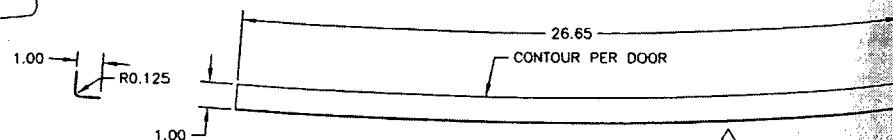
D3140-103 DOUBLER
D3140-104 OPPOSITE



D3140-301 DOUBLER $\triangle 3$ $\triangle 10$



D3140-303 DOUBLER $\triangle 3$ $\triangle 10$



D3140-85 ANGLE $\triangle 6$
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

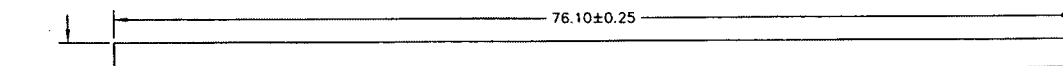
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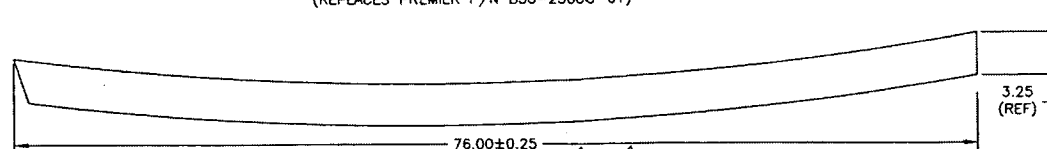
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DATE 05.11.23	TITLE DOOR	SCALE NTS	

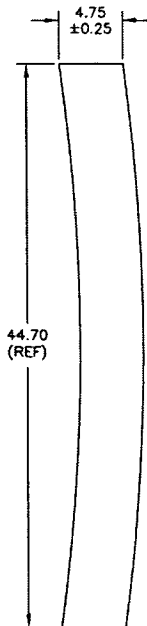
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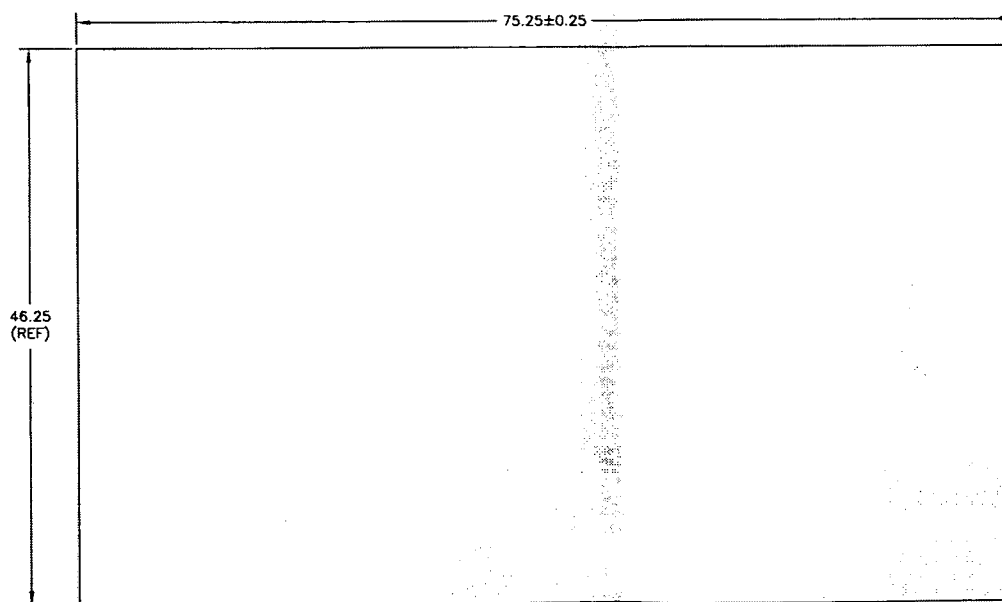
D3140-61 PAD 3 7
(REPLACES PREMIER P/N B30-23000-61)



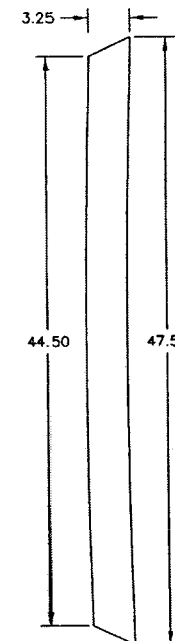
D3140-63 PAD 3 7
(REPLACES PREMIER P/N B30-23000-63)



D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)
3 7



D3140-59 PAD 7
(REPLACES PREMIER P/N B30-23000-59)



D3140-241 DOUBLER 5
(REPLACES PREMIER P/N B30-23000-241)

RELEASED
05.12.01

R1.00
(2 PLACES, REF)

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		DATE 05.11.23	TITLE DOOR	REV. D SHEET 7 OF 7
				SCALE NTS

